Work Order ID 66986

Thursday, March 03, 2011 10:02:16 AM

POSITIVE RECALL

Item ID: D4323-4 **Accept** **Setup Start**

Revision ID: PRELIM **Stop**

Item Name: N1 Access Cover, RH

Start Date: 3/3/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 3/11/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-03-3 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4323	~~PA1~~ PA4								
100		0.00							
HandThermo		0.00				x1			DL 11/03/01
Hand Finishing Thermoforming	**Memo** 1-Cut Sheet to required Blank size								
105		0.00							
HandThermo	Dry Material	0.00				x1			DL 11/03/01
Hand Finishing Thermoforming	**Memo** Dry Sheet as per QSI022 KYDEX								

Temp: 150°F

Time IN: 4:00 PM 11/02/28

Time OUT: 7:00 am 11/03/01

PRELIMINARY ISSUE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 66986

Thursday, March 03, 2011 10:02:16 AM

Item ID: D4323-4
Revision ID: PRELIM
Item Name: N1 Access Cover, RH

Start Date: 3/3/2011 **Start Qty:** 1.00
Required Date: 3/11/2011 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00				x1			DL 11/03/01
Thermoform	**Memo**	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg D4323-4and Folio #FTAxxx using tool DT9712 Dwg Rev: PA3 Folio Rev: A								PTO →
120	QC2- Inspect parts off machine FAI/FAIB	0.00				x1			DL 11/03/01
QC	**Memo**	0.00							
Quality Control	Visuallly inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00				1			BR 11/03/01
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D4323-4 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR: 66986		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
11/05/01	110	Small Web in Corner. RL	MD 11/05/15	Ship to customer as is web is outside final trim area. as per H.S.	11/03/01 WK.	MD 11/05/15	MD 11/05/15	S 11/03/07

NOTE: Date & initial all entries

Work Order ID 66986

Thursday, March 03, 2011 10:02:16 AM

Item ID: D4323-4
Revision ID: PRELIM
Item Name: N1 Access Cover, RH
Start Date: 3/3/2011 **Start Qty:** 1.00
Required Date: 3/11/2011 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
HandThermo	**Memo**	0.00				x1			DL 11/03/01
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				x1			DL 11/03/01
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00 – inspector to Part Dy only							
QC	**Memo**	0.00							
Quality Control		Dy 3/03/07							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 66986

Thursday, March 03, 2011 10:02:16 AM

Item ID: D4323-4
Revision ID: PRELIM
Item Name: N1 Access Cover, RH
Start Date: 3/3/2011 **Start Qty:** 1.00
Required Date: 3/11/2011 **Req'd Qty:** 1.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location:_____	0.00				11/3/08			
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00					11/5/16		
QC	**Memo**	0.00							
Quality Control									

MF
11-03-08

RD2370

POSITIVE RECALL
EFFECTIVE 11/05/13 AUTH
RELEASED DATE 11/05/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 10:02:21 AM

Work Order ID: 66986

Parent Item: D4323-4

Parent Item Name: N1 Access Cover, RH

Start Date: 3/3/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: New Issue 11-03-01 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,019.537	4.2	4.421053			

6185 KYDEX .080"

Location	Loc Qty	Loc Code
therm	1019.537564	
109703	81.189115	
116576	938.348449	

11/03/04

4.2 sq ft.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	66986
Description: Access cover RH	Part Number:	D4323-4
Inspection Dwg: D4323 Rev: ~~B~~ PA4		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than N/A"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL 11/03/04	Date:	11/03/04

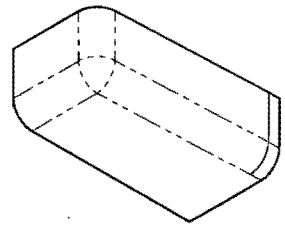
TRIMMING SECTION

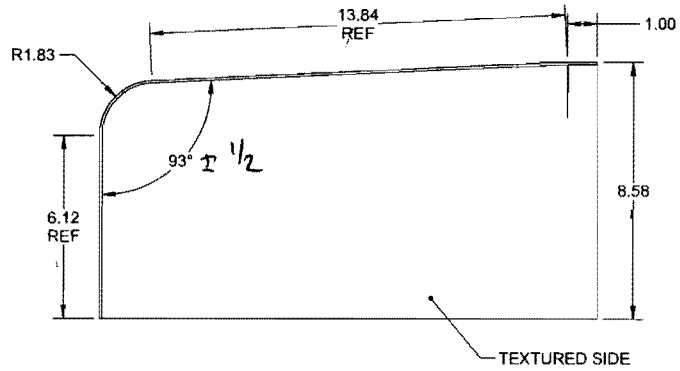
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.57"	+/- 0.030"	16.6"	✓			Revised Tolerances to PA4 See Attached DL 11/03/07
5.83"	+/- 0.030"	5.8"	✓			
8.578"	+/- 0.030	8.6"	✓			
93°	+/- ½°	93°	✓			
0.080"	+/- 0.030"	0.046"				

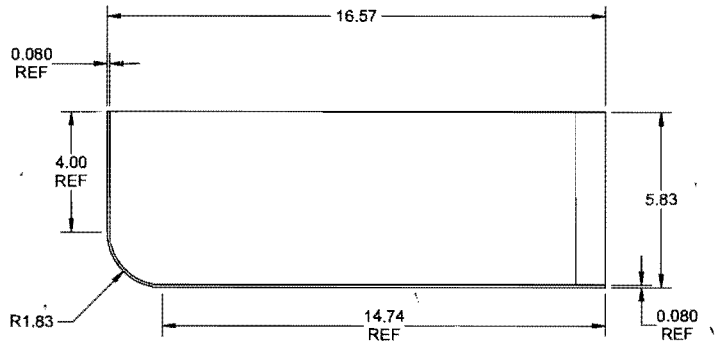
Measured by:	DL	Date:	11/03/04
Audited by:	S	Date:	11/03/07
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14







SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46986

RD 11-03-3

D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P1-HAIRCELL, IVORY #62015
REF DART SPEC MKYD6185S.080-P1-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 33.81 lbs
8) TOOLING: THERMOFORM -3 PART PER MOLD DT9711, AND -4 PART PER DT9712. TRIM PER MOLD

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	DC	
CHECKED		DRAWING NO. D4323 — REV. PA3 — SHEET 2 OF 11
MFG. APPR.		
APPROVED		TITLE: PANEL — SCALE: NTS
DE APPR.		
DATE 11.02.09		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Daryl Leger

From: Harvey Siemens [hsiemens@dartaero.com]
Sent: Thursday, March 03, 2011 4:05 PM
To: 'Daryl Leger'
Cc: dcampbell@dartaero.com
Subject: RE: D4323 parts

Daryl

I think the web should be ok. I believe that it will get trimmed anyways. The larger radius for the -17 part is ok too since its fitting over the cover not inside. Dan can make the necessary changes to the drawings if you need him to. Just let him know.

Thanks for the update

Regards,

Harvey Siemens
Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
E: hsiemens@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6
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From: Daryl Leger [mailto:dleger@dartaero.com]
Sent: March-03-11 1:25 PM
To: Harvey Siemens
Subject: D4323 parts

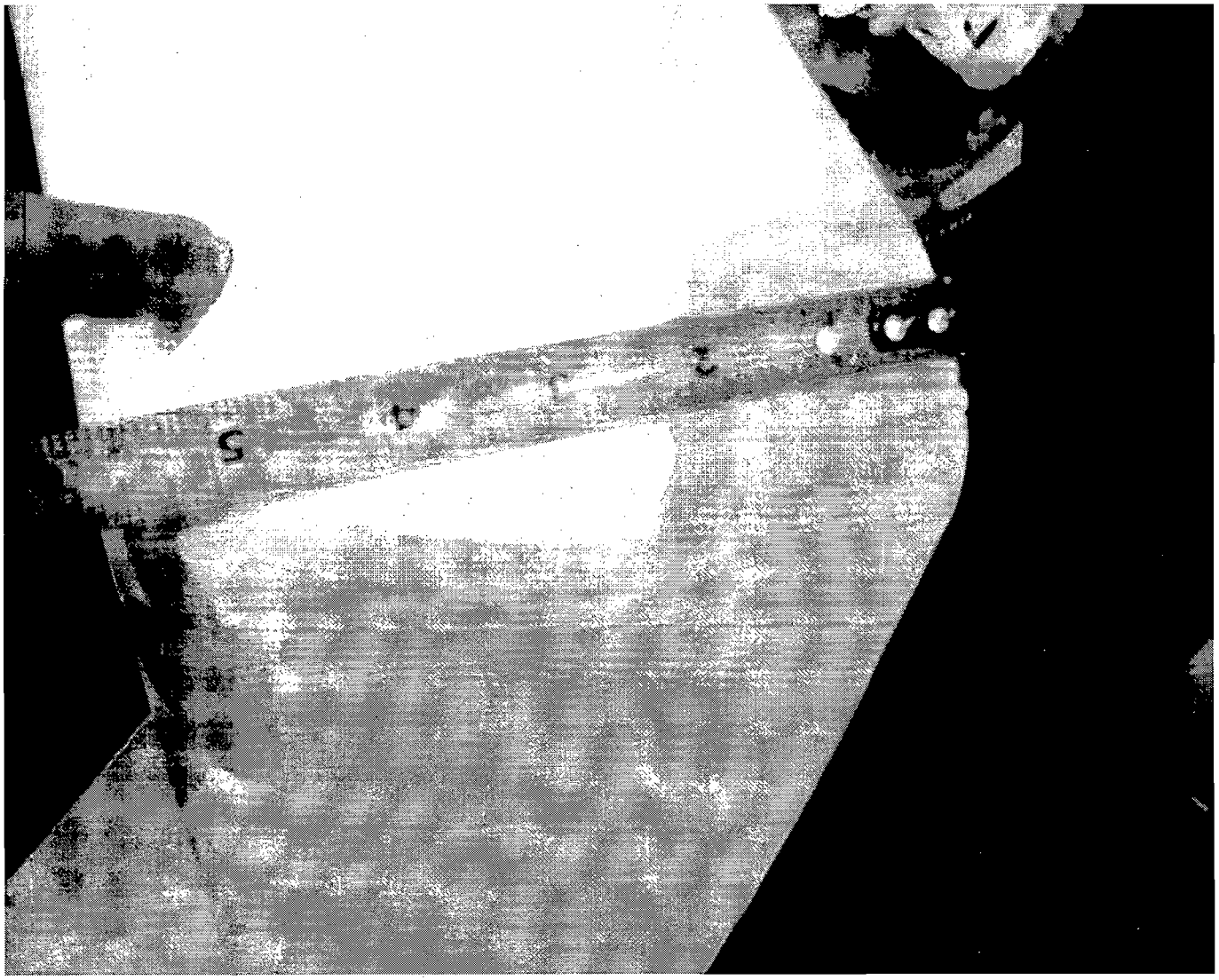
Hi Harvey

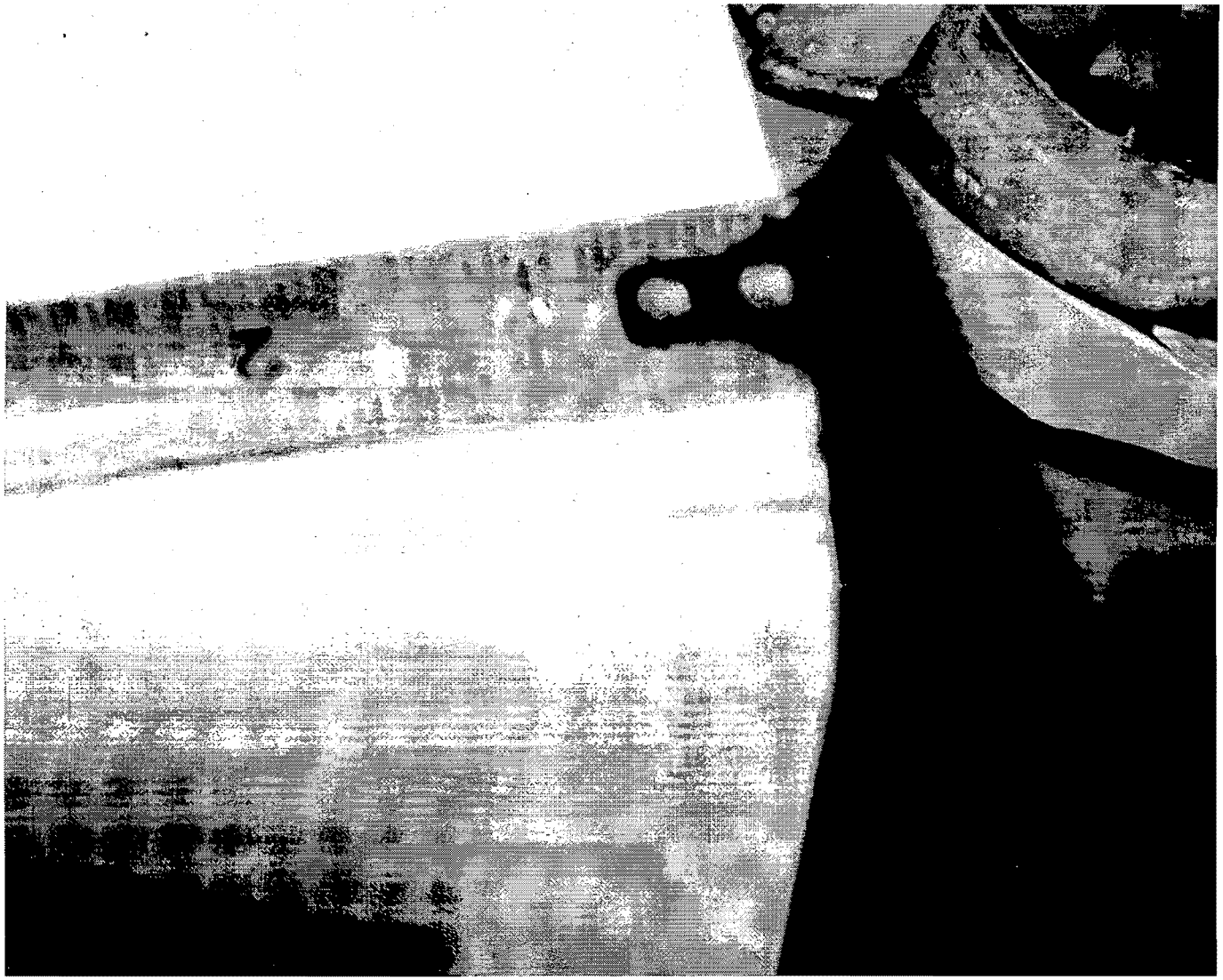
Here's a photo of the **small web that is on the D4323-4 part. The web is about ¾" long**, Will this part be OK to ship?
Also **the D4323-17 part actually has an inside radius of 10-3/4"** and not 10-1/2" as in the PA3 drawing, Is that OK as well?

If your OK with these deviations please flip me an e-mail so that I can attach it to the WO.

3/3/2011

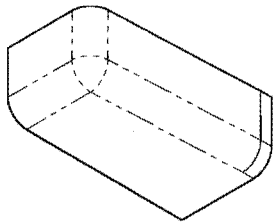
Thanks.

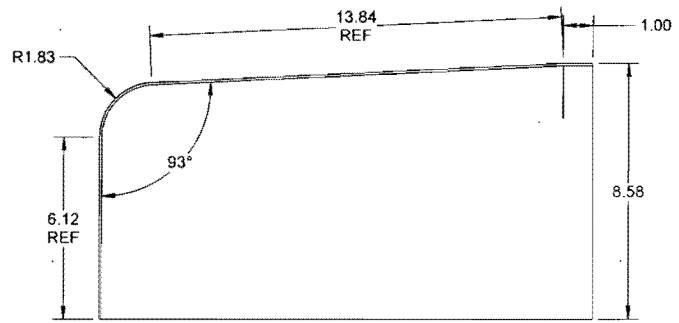


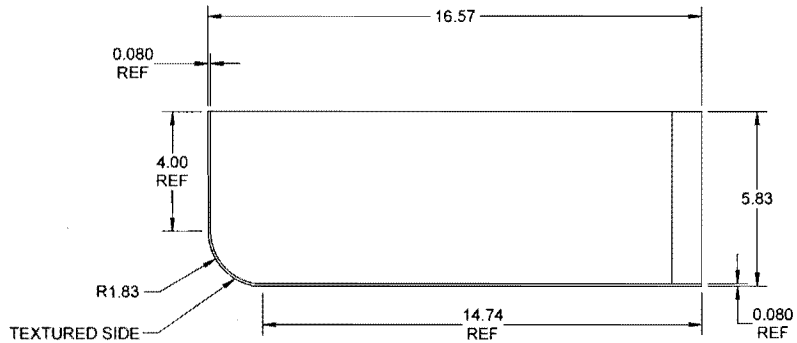


Daryl L. Leger
Production Engineering Co-ordinator
DART
aerospace
TEL: 613-632-5200
FAX: 613-632-1426
EMAIL: dleger@dartaero.com

3/3/2011







PRELIMINARY ISSUE

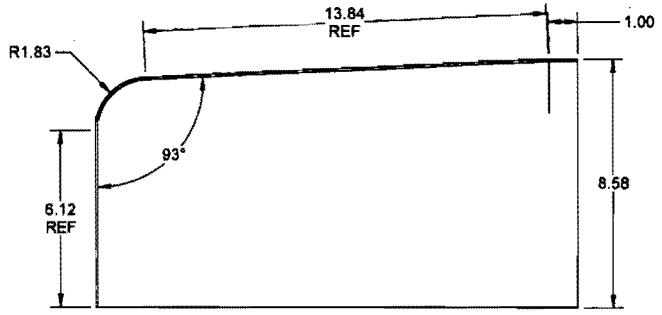
D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)

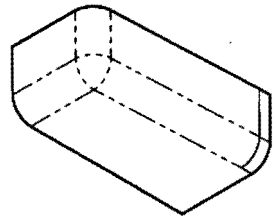
NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 33.81 lbs
8) TOOLING: THERMOFORM -3 PART PER MOLD DT9711, AND -4 PART PER DT9712. TRIM PER MOLD
9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

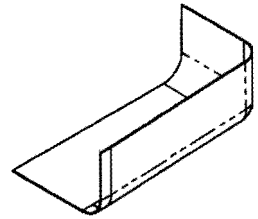
DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4323 REV. PA4 SHEET 3 OF 12
MFG. APPR.		
APPROVED		TITLE PANEL SCALE NTS
DE APPR.		
DATE	11.02.09	

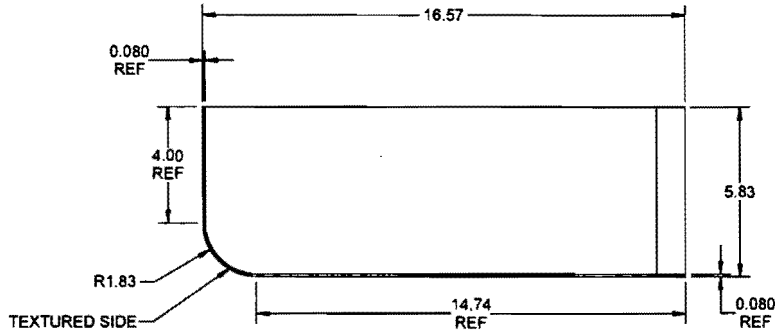
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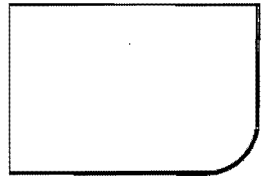
98699











D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)

RELEASED
2011 -05- 11

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 2.01 lbs
8) TOOLING: THERMOFORM -3 PART PER MOULD DT9711, AND -4 PART PER DT9712 AND PER DART QSI 022. TRIM PER MOULD
9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4323 — REV. A
MFG. APPR.		SHEET 3 OF 15
APPROVED		TITLE: PANEL — SCALE: NTS
DE APPR.		
DATE	11.04.21	

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